

Work Order ID 86831

86831

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July-06-12 3:02:42 PM

Item ID: D2151 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Packer Doubler, Hinge
 Start Date: 7/06/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 12-07-9 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2151 | Rev B | | | | | | | | |

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2151 Dwg Rev: B Prog Rev: B 2-
 2029. 0.00 Debur if necessary
 20 0 Jm 12-7-23

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control
 20 0 Jm 12-7-23

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control
 20
 Smp 12-7-24
 DAS 16 8-8 12/1/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | Small Fab | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Deburr | | | | | | | | |
| | | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| | | | | | | | | | |
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: 9:30 | | | | | | | | |
| | FINISH TIME: 10:00 | | | | | | | | |

20 7/6/12 7:25

M-F

12/27/27

20X0

M121841

| W/O: | | WORK ORDER CHANGES | | | | | |
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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | 20 | 0 | BR 12-7-07 | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: <u>6</u> | 0.00 | | | | | | | |
| *170* | | | | | | 20 | | 12/7/27sf | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | 12/7/31 | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MCS 12/07/30

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

July-06-12 3:02:41 PM

Work Order ID: 86831

Parent Item: D2151

Parent Item Name: Packer Doubler, Hinge

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C00.10.23Re-format (mpp 2101)EC
IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
IPP Rev:E 06-11-24 As per Rev B JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|-------------------------------|---------------|----------------|--------|
| M2024T3S.040 2024-T3 .040 sheet | | Purchased | No | | | 110 | sf | 178.1612 | 0.035 | 0.736842 0.8075 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | MAT022 | | 178.1611626 | | | | | | | |
| | | | | 120605 | | 49.6627416 | | | | | | | |
| | | | | 121197 | | 32.498421 | | | | | | | |
| | | | | 122136 | | 96 | | | | | | | |
| | | | | | | | | | | 122136 | | | |

Jul 12-7-23

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|--|--|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | 86831 |
| Description: Packer | | Part Number: | D2151 |
| Inspection Dwg: D2151 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | 0.099" | ✓ | | ✓ | mm01 |
| Ø0.171 | +0.005/-0.000 | 0.172" | ✓ | | ✓ | " |
| 0.231 | +/-0.010 | 0.232" | ✓ | | ✓ | " |
| 1.217 | +/-0.010 | 1.219" | ✓ | | ✓ | " |
| 2.194 | +/-0.010 | 2.193" | ✓ | | ✓ | " |
| 2.300 | +/-0.010 | 2.302" | ✓ | | ✓ | " |
| 1.560 | +/-0.010 | 1.563" | ✓ | | ✓ | " |
| 0.250 | +/-0.010 | 0.249" | ✓ | | ✓ | " |
| 1.328 | +/-0.010 | 1.327" | ✓ | | ✓ | " |
| 0.342 | +/-0.010 | 0.344" | ✓ | | ✓ | " |
| 0.740 | +/-0.010 | 0.738" | ✓ | | ✓ | " |
| 2.050 | +/-0.010 | 2.054" | ✓ | | ✓ | " |
| 0.040 | +/-0.010 | 0.040" | ✓ | | ✓ | " |
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|------------------------|----------------------------|----------------------------|-----|
| Measured by: JM | Audited by: SMB DAS | Prototype Approval: | N/A |
| Date: 12-7-23 | Date: 12-7-24 15 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A | 04.08.12 | New Issue | KJ/JLM | |
| B | 06.11.24 | Dwg Revision revised | KJ/JLM | BE |

Dart Aerospace Ltd

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NOTE: Date & initial all entries



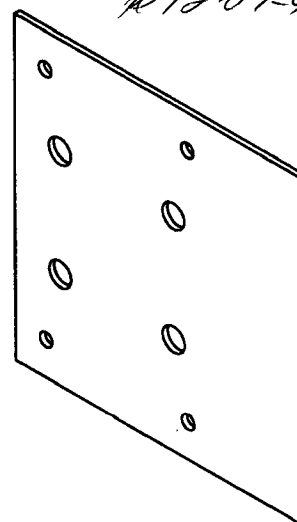
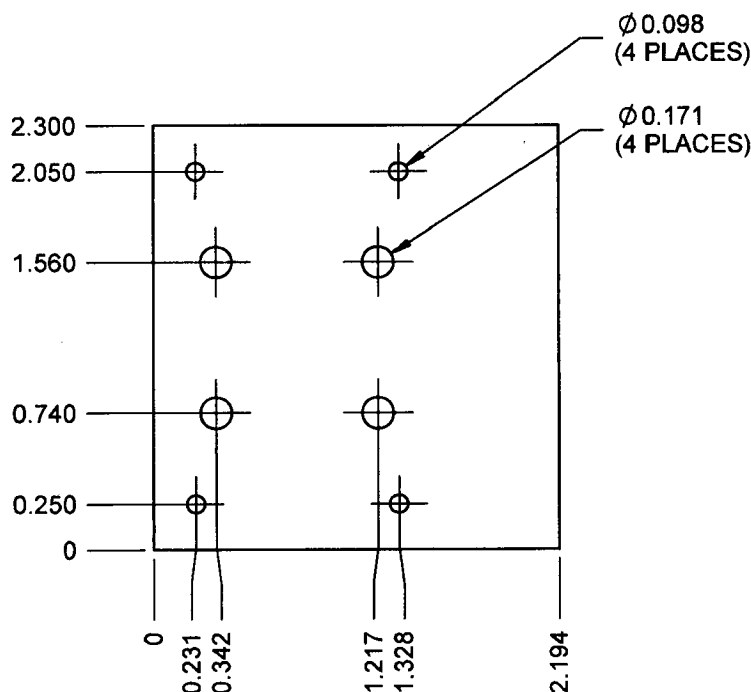
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|------------------|-------------------------|---|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED [Signature] | DRAWING NO. D2151 | REV. B SHEET 1 OF 1 |
| DATE 06.10.13 | | TITLE PACKER | SCALE 1:1 |
| REV | DATE | DESCRIPTION | |
| A | 95.05.01 | NEW ISSUE | |
| B | 06.10.13 | UPDATE DRAWING | |

RELEASED

06.11.20 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86831

D1207-9



D2151 PACKER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

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